

Date: Tuesday, 12/5/2006 8:04:04 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE ASSEMBLY LH  
 Job Number : 29753  
 Estimate Number : 10266  
 P.O. Number : N/A Part Number : D350636013  
 This Issue : 12/5/2006 S.O. No. : N/A Drawing Number : D2750 REV D  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : D  
 Previous Run : 29752 Material : N/A  
 Due Date : 1/5/2007 Qty: 1 Um: Each  
 Written By : KA 061205  
 Checked & Approved By : KA 061205  
 Comment : Est Rev: H 02.09.25 Rearranged procedure steps KJ  
 est rev I 06.03.30 Per rev. D dwg EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-013 CHG 002

KJ 06.12.08 (1)

2.0 D26003BENT Extrusion Bent



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

B29327

RT 06-12-14

3.0 D2744 Fwd Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cap

Batch:

B27559

BE

06-12-15

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 3 (D2750-1 details). Drill using drill Jig DT8150 &amp; DT8864 drilling holes labelled "B" only.

3- Mark fwd end for cutting using Drill Jig DT 8150 &amp; DT8864 and cut as per dwg D2750.

RT

06-12-14

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
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NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29753

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Drill pilot holes for Detail B using DT8330

5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 and open to 0.250" \*\*\*Make sure that wearplate holes are on bottom of tube\*\*\*\*\*

6-Open up holes of Detail A to 0.250" (total of 2 holes per side)

7- Countersink all fwd wearshoe holes (total of 19 holes per side) DO NOT C'SINK THE LAST AFT HOLES (total of 2 per side for blade fitting) as per dwg D2750.

8-Countersink Detail A as per dwg D2750.

9-Open up holes for Detail B, "hole size W" and blade fitting location holes to 0.500" (total of 9 holes per side) as per dwg D2750.

10-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod *m101446 BE 06-12-15*

11-Grind welds flush as per Dwg D2750

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Web

Batch:

*B29977*

*Pm 07-01-02*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                                |                                 |                |                           |                       |                          |
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29753

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D34901

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: B28874 BE 07-01-03 ①

11.0

D34905

CROSS BOLT SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Crossbolt spacer

Batch: B29870 BE 07-01-03 ①

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Crossbolt Spacer

Batch: B25838 BE 07-01-03 ①

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes "size X" (total of 4 holes per side) as per dwg D2750 Pm 07-01-02 ①

2-Open up holes of Detail V & Detail C to 0.625" (total of 8 holes per side) as per dwg D2750. Pm 07-01-02 ①

3-Chamfer holes of Detail V, Detail C, hole size "W" and "X" per dwg D2750 (welding instructions on sheet 5) Pm 07-01-02 ①

4-Deburr and blow out all chips from inside of tube Pm 07-01-02 ①

5-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: M102672

exp. date: 07-02-01 Pm 07-01-02 ①

6- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 5)

A/R

Aluminum Rod

batch: M101446 BE 07-01-03 ①

7-Grind welds flush as per Dwg D2750 Pm 07-01-03 ①

8-Spot face ground handling holes section J-J (total of 4 places per side) as per dwg D2750 Pm 07-01-03 ①

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29753

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

9-Deburr holes

*Pm '07-01-04*

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*MA 07/01/04*

*①*

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*MA 07/01/04*

*①*

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

*FR/w.m*

*07/01/15*

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Inspect for foreign object per QSI 024

*YR*

*07/01/18 x①*

18.0

NAS1330S3KB166

INSERT



Comment: Qty.: 42.0000 Each(s)/Unit Total: 42.0000 Each(s)

INSERT

Batch:

*103183*

*a.m 07/01/18*

*①*

19.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts as per dwg D2750

*a.m 07/01/18*

*①*

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT INSERTS

*FC 07/01/18*

*①*

21.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Wearpad

Batch:

*1528249*

*a.m 07/01/18*

*①*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29753

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B27739

23.0

D265635

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B26206

24.0

D2746

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearplate

Batch: B27485

25.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bushing

Batch: B28974

26.0

D3488041

BLADE FITTING ASSEMBLY, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, LH

Batch: B28318

27.0

D3492041

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: B29044

q.m 07/01/08 (1)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29753

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D3492045

PLUG ASSEMBLY



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

PLUG ASSEMBLY

Batch: *B29018*

29.0

AN3C5A

Bolt



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

Bolt

Batch: *M103044 X2*

*M102985 36X*

30.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: *M19522*

31.0

AN3C7A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: *M19522*

32.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: *M102410*

33.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: *M102180*

34.0

AN960C10L

washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

washer

Batch: *B102079*

*a.m 01/01/18 (1)*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29753

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M100186

36.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

NUT

Batch: M102332

37.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

NUT

Batch: M100186

38.0

NAS1515H3L

WASHER



Comment: Qty.: 46.0000 Each(s)/Unit Total: 46.0000 Each(s)

WASHER

Batch: M101542

39.0

NAS1515H8L

WASHER



Comment: Qty.: 10.0000 Each(s)/Unit Total: 10.0000 Each(s)

WASHER

Batch: M102535

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside of tube with "LPS-3" batch: M101915

Inspect for foreign objects as Dart QSI 024

2-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M102672

EXP DATE: 02/07

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |
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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29753

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Coat all exposed fasteners with "LPS Procyon" batch: M17168 2.2 07/01/18 (1)

41.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/01/22 (1)

42.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

43.0

D2741

Blade



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade

Batch: M28521 - ✓

44.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M100186 - ✓

45.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M100186 - ✓

46.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M102735 - ✓

47.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: M102515 - ✓

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/11/25

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
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Date: Tuesday, 12/5/2006 8:04:06 AM  
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## Process Sheet

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Drawing Name: 350 SKIDTUBE ASSEMBLY LH

Job Number: 29753

Part Number: D350636013

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

D34931

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

WASHER

Batch: 329365 ✓

*CO 7/01/23 (1)*

49.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

*C 207101123 (1)*

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-013 *NR*

*671-1-04*

51.0

QC21

FINAL INSPECTION/W/O RELEASE



*(1)*

Comment: FINAL INSPECTION/W/O RELEASE

*207101125*

Job Completion



*2070125*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

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06-02-07

|                               |                                |   |                        |
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| DESIGN<br><i>P44</i>          | DRAWN BY<br><i>P44</i>         | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA                     |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2750  | REV. D<br>SHEET 1 OF 5 |
| DATE<br>06.01.05              |                                | TITLE<br>350 SKIDTUBE ASSEMBLY  | SCALE<br>NTS           |
| A                             | 98.04.16                       | NEW ISSUE   |                        |
| B                             | 98.09.01                       | CHANGE MS24694-S293 TO AN8-16A  |                        |
| C                             | 98.11.18                       | ADD D2750-3/D2750-4<br>INCORPORATE D2738 AND D2740                      |                        |
| D                             | 06.01.05                       | ADD HOLES AND SPACERS FOR<br>APICAL FLOATS<br>INCORPORATE DEO 9133/9157 |                        |

| Qty<br>-041 | Qty<br>-042 | Qty<br>-043 | Qty<br>-044 | Part Number    | Description           |
|-------------|-------------|-------------|-------------|----------------|-----------------------|
| X           |             |             |             | D2750-041      | SKIDTUBE ASSEMBLY, LH |
|             | X           |             |             | D2750-042      | SKIDTUBE ASSEMBLY, RH |
|             |             | X           |             | D2750-043      | SKIDTUBE ASSEMBLY, LH |
|             |             |             | X           | D2750-044      | SKIDTUBE ASSEMBLY, RH |
| 5           | 5           | 5           | 5           | D2648-3        | WEARPAD               |
| 1           | 1           | 1           | 1           | D2656-13       | WEARSHOE              |
| 1           | 1           | 1           | 1           | D2656-35       | WEARSHOE              |
| 1           | 1           | 1           | 1           | D2746          | WEARSHOE              |
| 1           | 1           | 1           | 1           | D2739          | WEB                   |
| 1           | 1           | 1           | 1           | D2741          | BLADE                 |
| 8           | 8           | 8           | 8           | D2743          | SPACER                |
| 1           | 1           | 1           | 1           | D2744          | CAP                   |
| 8           | 8           | 8           | 8           | D2745          | BUSHING               |
| 1           |             |             |             | D2750-1        | SKIDTUBE WELDMENT, LH |
|             | 1           |             |             | D2750-2        | SKIDTUBE WELDMENT, RH |
|             |             | 1           |             | D2750-3        | SKIDTUBE WELDMENT, LH |
|             |             |             | 1           | D2750-4        | SKIDTUBE WELDMENT, RH |
| 1           |             | 1           |             | D3488-041      | BLADE FITTING, LH     |
|             | 1           |             | 1           | D3488-042      | BLADE FITTING, RH     |
| 4           | 4           | 4           | 4           | D3490-1        | SPACER                |
| 4           | 4           |             |             | D3490-3        | SPACER                |
|             |             | 4           | 4           | D3490-5        | SPACER                |
| 8           | 8           | 8           | 8           | D3492-041      | PLUG ASSEMBLY         |
| 8           | 8           |             |             | D3492-043      | PLUG ASSEMBLY         |
|             |             | 8           | 8           | D3492-045      | PLUG ASSEMBLY         |
| 38          | 38          | 38          | 38          | AN3C5A         | BOLT                  |
| 4           | 4           | 4           | 4           | AN3C6A         | BOLT                  |
| 4           | 4           | 4           | 4           | AN3C7A         | BOLT                  |
| 4           | 4           | 4           | 4           | AN6C44A        | BOLT                  |
| 2           | 2           | 2           | 2           | AN8C21A        | BOLT                  |
| 1           | 1           | 1           | 1           | AN8C35A        | BOLT                  |
| 46          | 46          | 46          | 46          | AN960C10L      | WASHER                |
| 4           | 4           | 4           | 4           | AN960C816L     | WASHER                |
| 4           | 4           | 4           | 4           | MS21043-6      | NUT                   |
| 3           | 3           | 3           | 3           | MS21083C8      | NUT                   |
| 42          | 42          | 42          | 42          | NAS1330S3KB166 | INSERT                |
| 46          | 46          | 46          | 46          | NAS1515H3L     | WASHER                |
| 12          | 12          | 12          | 12          | NAS1515H8L     | WASHER                |

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| CHECKED<br>PH    | APPROVED<br>PH | DRAWING NO.<br>D2750                         | REV. D<br>SHEET 2 OF 5 |
| DATE<br>06.01.05 |                | TITLE<br>350 SKIDTUBE ASSEMBLY               | SCALE<br>NTS           |

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06.02.07

GENERAL NOTES:

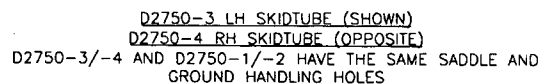
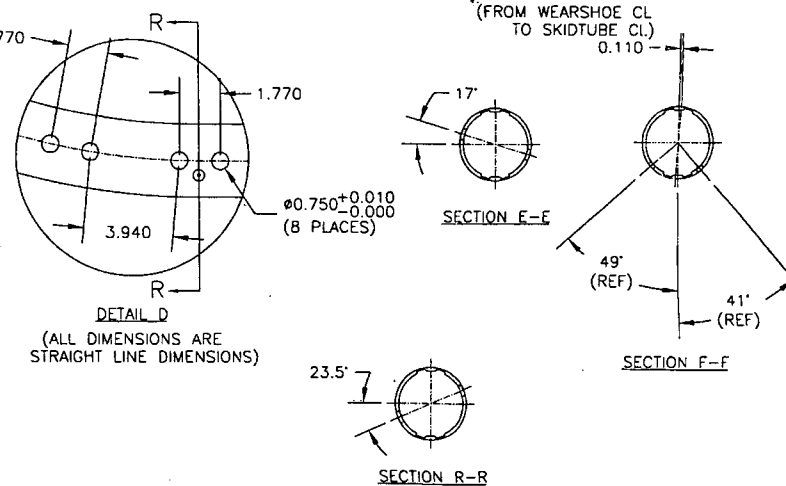
1. ALL DIMENSIONS ARE IN INCHES
2. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
3. MAKE FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
4. DAMAGE TOLERANCE ON BENDING:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 12 INCHES ABOVE THE GROUND. NO GOUGING IS ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. GOUGES UP TO 0.020 ARE ACCEPTABLE IN THE BENT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE O.D. SHOULD BE  $3.15 \pm 0.030$  IN THE BENT PORTION OF THE TUBE.
5. ALL HOLES DRILLED ON CENTERLINES EXCEPT THOSE NOTED BY SECTIONS E-E, F-F, AND R-R.
6. WELDING TO BE DONE PER DART QSI 004.
7. FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
8. FINISH:  
ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
9. INSTALL NAS1330S3KB166 INSERTS AFTER FINISH AS INDICATED IN D2750-1/-2/-3/-4 WELDING DETAIL ON PAGE 4 AND 5. DRILL 'E' SIZE HOLES ( $\emptyset 0.250$ - $\emptyset 0.257$ ) FOR WEARSHOE INSERTS. C'SINK  $\emptyset 0.391 \times 100^\circ$  AND INSTALL INSERTS
10. D3488-041 (OR D3488-042) BLADE FITTING AND AN3-5A/AN3-7A WEARSHOE SCREWS TO BE INSTALLED USING SIKAFLEX-241 (OR EQUIVALENT) SEALANT.
11. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
12. APPLY A LAYER OF SIKAFLEX -241/-291 ADHESIVE BETWEEN THE BOTTOM OF THE SKIDTUBE ASSEMBLY AND THE WEARPLATES

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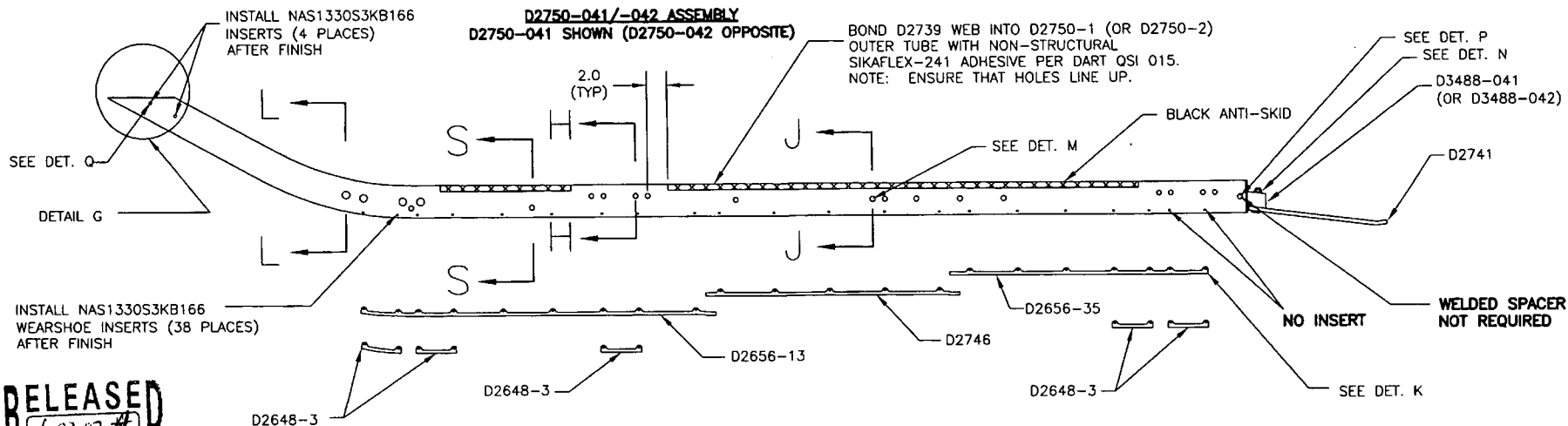
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| 06.01.05 |   |          |   |

|                       |              |
|-----------------------|--------------|
| DRAWING NO.           | REV. 0       |
| D2750                 | SHEET 3 OF 5 |
| TITLE                 | SCALE        |
| 350 SKIDTUBE ASSEMBLY | 1:20         |

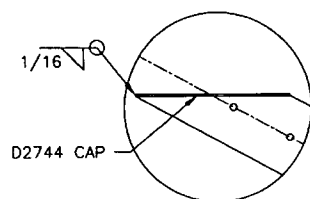
**D2750-041/-042 ASSEMBLY**  
**D2750-041 SHOWN (D2750-042 OPPOSITE)**

BOND D2739 WEB INTO D2750-1 (OR D2750-2)  
 OUTER TUBE WITH NON-STRUCTURAL  
 SIKAFLEX-241 ADHESIVE PER DART QSI 015.  
 NOTE: ENSURE THAT HOLES LINE UP.

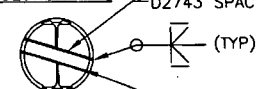


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 06-02-07 #

**DETAIL G**



**SECTION H-H**

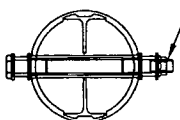


**SECTION J-J**



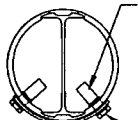
- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
  2. INSERT D2743 SPACER
  3. WELD INTO PLACE
  4. GRIND FLUSH
  5. DRILL OUT SPACER TO Ø0.484
  6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

**DETAIL M**



- AN6-44A BOLT (1)  
 D2745 BUSHING (2)  
 NAS1515H8L WASHER (2)  
 MS21043-6 NUT (1)  
 (4 PLACES)  
**NOTE: INSTALL WASHER BETWEEN SKIDTUBE AND BUSHING**

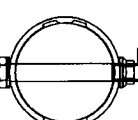
**DETAIL K**



USE AN3C7A BOLTS  
 FOR INSTALLING AFT  
 D2648-3 WEARPAD  
 (4 PLACES)

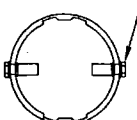
- AN3C5A BOLT (1)  
 AN960JD10L WASHER (1)  
 NAS1515H3L WASHER (2)  
 (38 PLACES)

**DETAIL P**



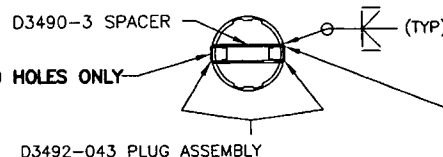
- AN8C35A BOLT (1)  
 AN960C816L WASHER (2)  
 NAS1515H8L WASHER (2)  
 MS21083C8 NUT (1)

**DETAIL Q**



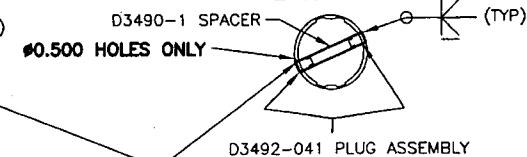
- AN3C6A BOLT (1)  
 AN960C10L WASHER (1)  
 NAS1515H3L WASHER (1)  
 (4 PLACES)

**SECTION L-L**



Ø0.750 HOLES ONLY

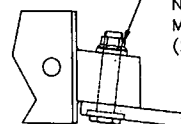
**SECTION S-S**



Ø0.500 HOLES ONLY

- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
  2. INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES OR INSERT D3490-3 SPACER (4 PLACES) INTO Ø0.750 HOLES
  3. WELD INTO PLACE
  4. GRIND FLUSH
  5. INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER OR INSERT D3492-043 PLUG ASSEMBLY (8 PLACES) INTO D3490-3 SPACER ON BOTH ENDS

**DETAIL N**



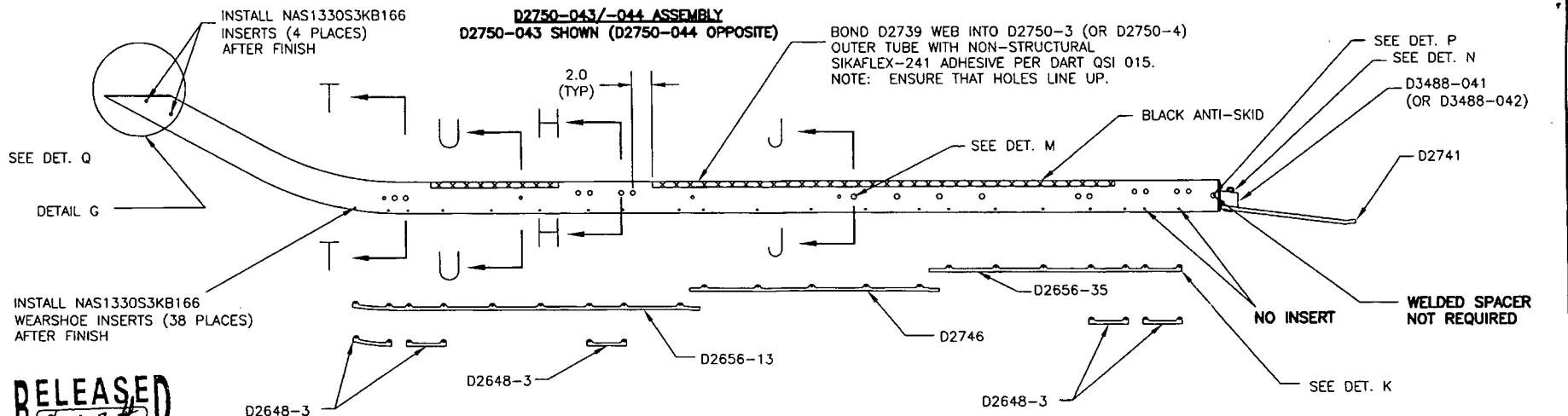
- AN8C21A BOLT (1)  
 AN960JD816L WASHER (1)  
 NAS1515H8L WASHER (1)  
 MS21083C8 NUT (1)  
 (2 PLACES)

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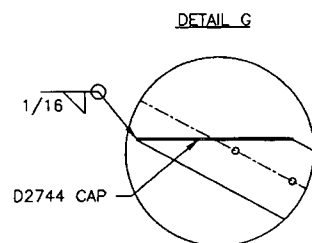
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| DATE<br>06.01.05 |                | TITLE<br>350 SKIDTUBE ASSEMBLY                           | SCALE<br>1:20 |

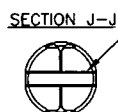
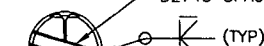
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**SECTION H-H**



- WELDING INSTRUCTIONS**
1. CHAMFER HOLE 0.050 X 45°
  2. INSERT D2743 SPACER
  3. WELD INTO PLACE
  4. GRIND FLUSH
  5. DRILL OUT SPACER TO Ø0.484
  6. SPOT FACE Ø0.750 (SECTION J-J ONLY)

**SECTION T-T**



Ø0.500 HOLES ONLY

D3492-041 PLUG ASSEMBLY

**SECTION U-U**

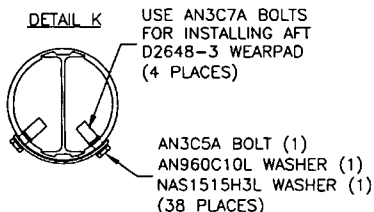


Ø0.313 HOLES ONLY

D3492-045 PLUG ASSEMBLY

**WELDING INSTRUCTIONS**

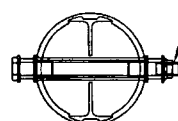
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D3490-5 SPACER (4 PLACES) INTO Ø0.313 HOLES OR INSERT D3490-1 SPACER (4 PLACES) INTO Ø0.500 HOLES
3. WELD INTO PLACE
4. GRIND FLUSH
5. INSERT D3492-045 PLUG ASSEMBLY (8 PLACES) INTO D3490-5 SPACER OR INSERT D3492-041 PLUG ASSEMBLY (8 PLACES) INTO D3490-1 SPACER ON BOTH ENDS



USE AN3C7A BOLTS FOR INSTALLING AFT D2648-3 WEARPAD (4 PLACES)

AN3C5A BOLT (1)  
 AN960C10L WASHER (1)  
 NAS1515H3L WASHER (1)  
 (38 PLACES)

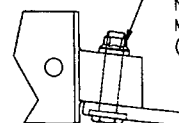
**DETAIL M**



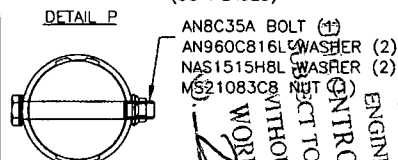
AN6C44A BOLT (1)  
 D2745 BUSHING (2)  
 NAS1515H8L WASHER (2)  
 MS21043-6 NUT (1)  
 (4 PLACES)

NOTE: INSTALL WASHER BETWEEN SKIDTUBE AND BUSHING

**DETAIL N**

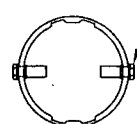


AN8C21A BOLT (1)  
 AN960JD816L WASHER (1)  
 NAS1515H8L WASHER (1)  
 MS21083C8 NUT (1)  
 (2 PLACES)



AN8C35A BOLT (1)  
 AN960C816L WASHER (2)  
 NAS1515H8L WASHER (2)  
 MS21083C8 NUT (2)  
 (4 PLACES)

**DETAIL Q**



AN3C6A BOLT (1)  
 AN960C10L WASHER (1)  
 NAS1515H3L WASHER (1)  
 (4 PLACES)

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| CHECKED | #        | APPROVED    | #     | PORT HADLOCK, WA                     | SHEET 5 OF 5          |
| DATE    | 06.01.05 | DRAWING NO. | D2750 | TITLE                                | 350 SKIDTUBE ASSEMBLY |
|         |          |             |       | SCALE                                | 1:20                  |

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NO. 82

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name Barclay Elliott  
Joint Welding Procedure Tig  
Part number and Job number A350 636 011/B29428

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

|              | Position                    | Vertical                    | Down <input type="checkbox"/> | Up <input type="checkbox"/> |
|--------------|-----------------------------|-----------------------------|-------------------------------|-----------------------------|
| Sheet Groove | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 3G <input type="checkbox"/>   | 4G <input type="checkbox"/> |
| Tube Groove  | 1G <input type="checkbox"/> | 2G <input type="checkbox"/> | 5G <input type="checkbox"/>   | 6G <input type="checkbox"/> |
| Sheet Fillet | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 3F <input type="checkbox"/>   | 4F <input type="checkbox"/> |
| Tube Fillet  | 1F <input type="checkbox"/> | 2F <input type="checkbox"/> | 4F <input type="checkbox"/>   | 5F <input type="checkbox"/> |

Crossbolt Spacer Welded into \_\_\_\_\_ Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 06/12/18 Qualifier David David